

Work Order ID 74907***74907***

Page 1

Thursday, October 13, 2011 11:33:58 AM

Item ID: D4055-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Upper Cut Out
Start Date: 10/13/2011 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 10/20/2011 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: 11 Date: 11-10-13 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	B								

100 0.00

100

Purchasing

Memo

Purchasing

Issue P/O: 15139

Purchase part as per Dwg D4055

Possible Supplier: GFI

Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

Packaging

0.00

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

Quality Control

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>119</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

5X DM 11/11/01

11/11/01 SP 5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID: Stop *NS2*
Item Name: Tank Upper Cut Out
Start Date: 10/13/2011 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 10/20/2011 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/11/01
ME 11-11-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 13, 2011 11:34:03 AM

Page 1

Work Order ID: 74907

Parent Item: D4055-5

Start Date: 10/13/2011

Required Date: 10/20/2011

Parent Item Name: Tank Upper Cut Out

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P Tank Upper Cut Out		Purchased	No			110	Each	0.0000	1	5			

10/14/31 5

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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

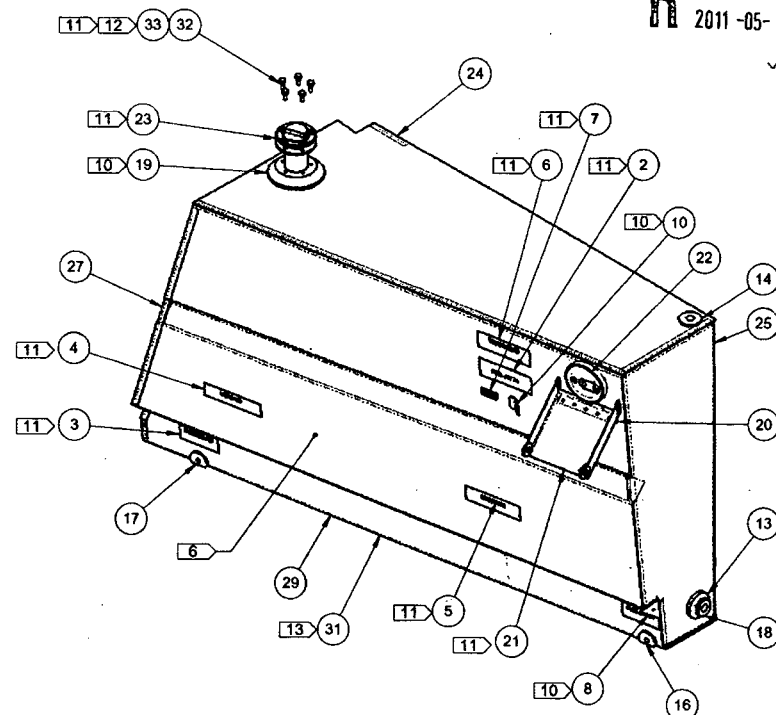
D4055-041 FUEL TANK ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 34907

M.L.J

11/10/13



RELEASED
2011-05-30

B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4055 TITLE TANK REV. B SHEET 1 OF 15 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

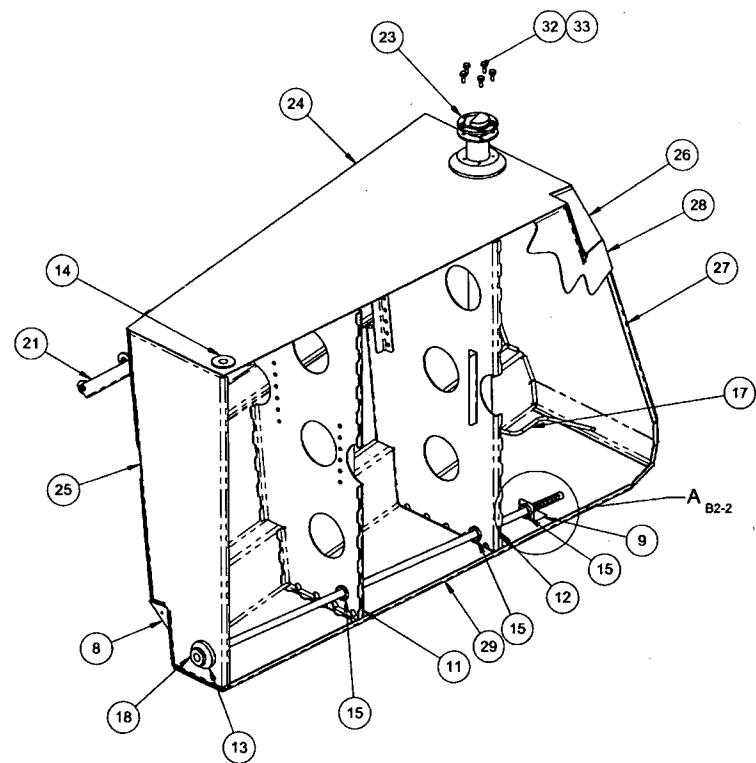
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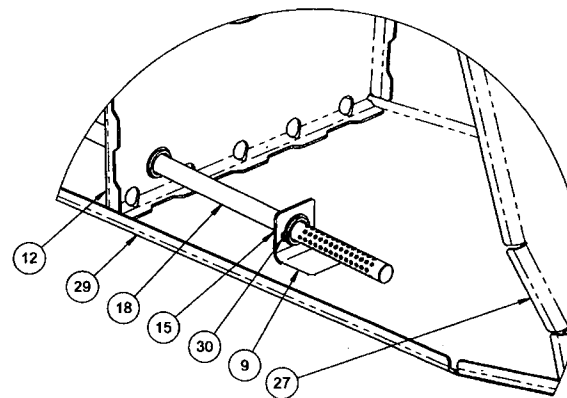
NOTE: Date & initial all entries

74807

RELEASED
2011-05-30
MD



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. B
MFG. APPR.		SHEET 2 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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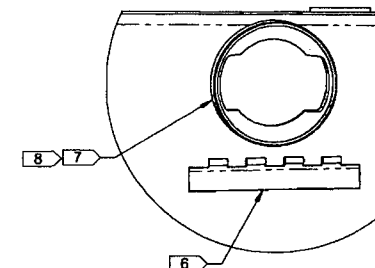
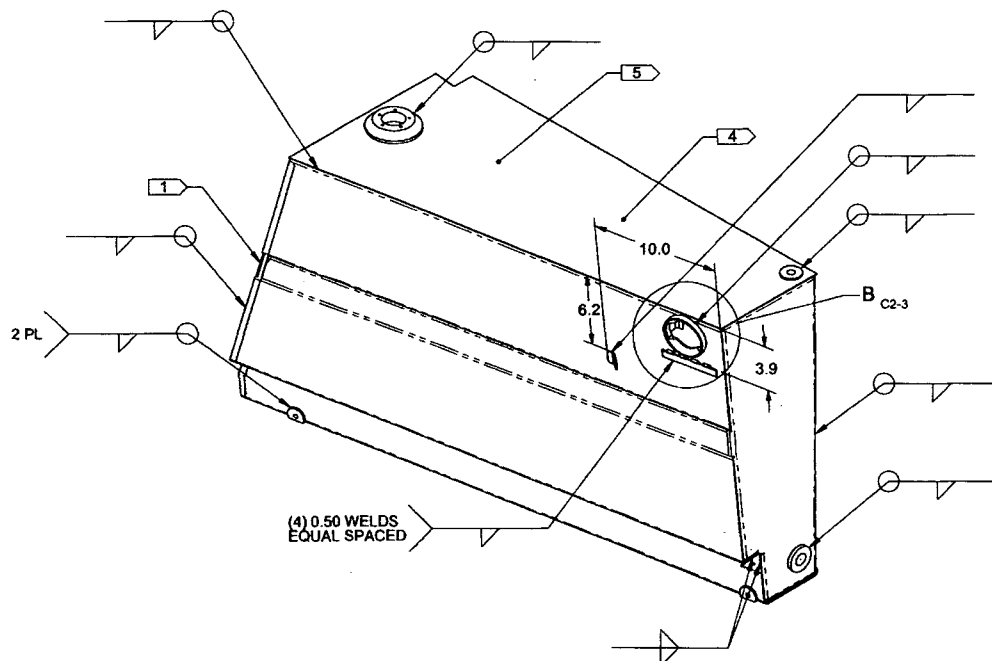
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NOTE: Date & initial all entries

74807



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

C4-3

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

RELEASED
2011-05-30

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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 3 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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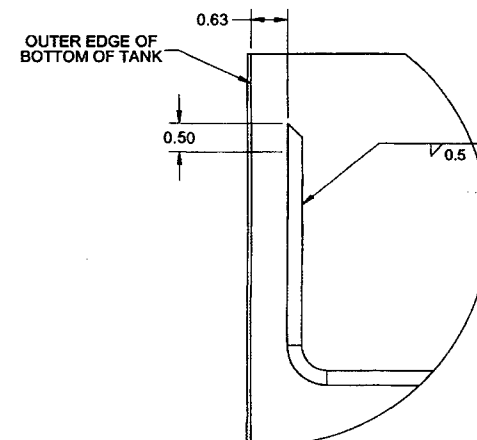
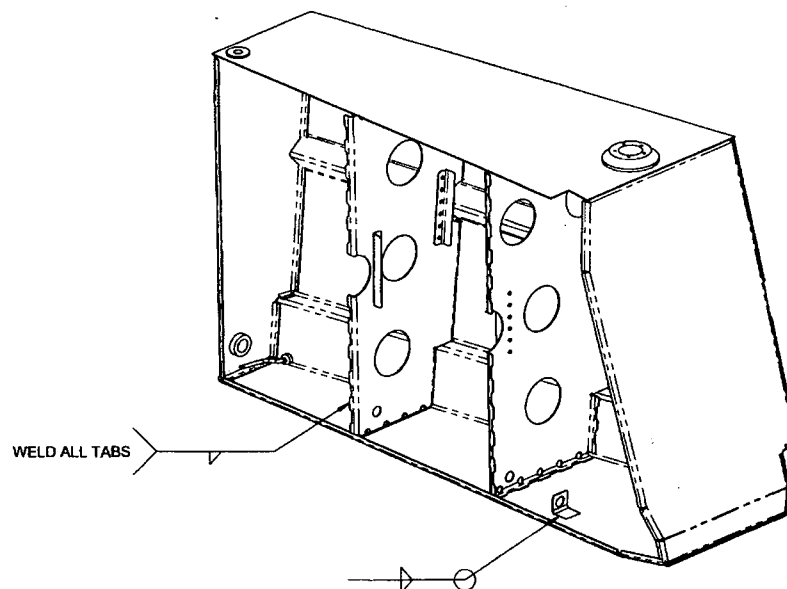
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NOTE: Date & initial all entries

74807



**DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2011-05-30
JW

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D4055	REV. B
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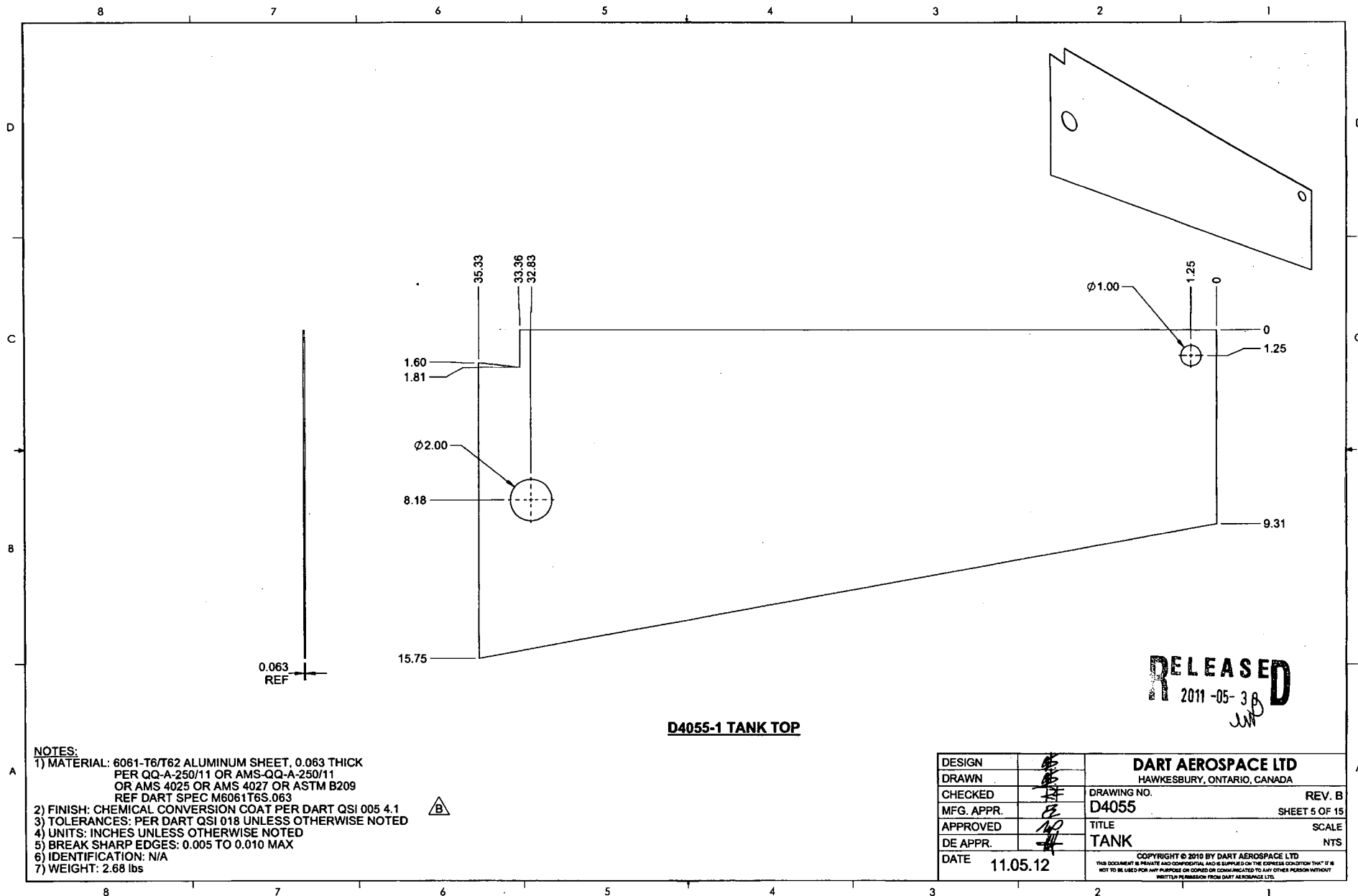
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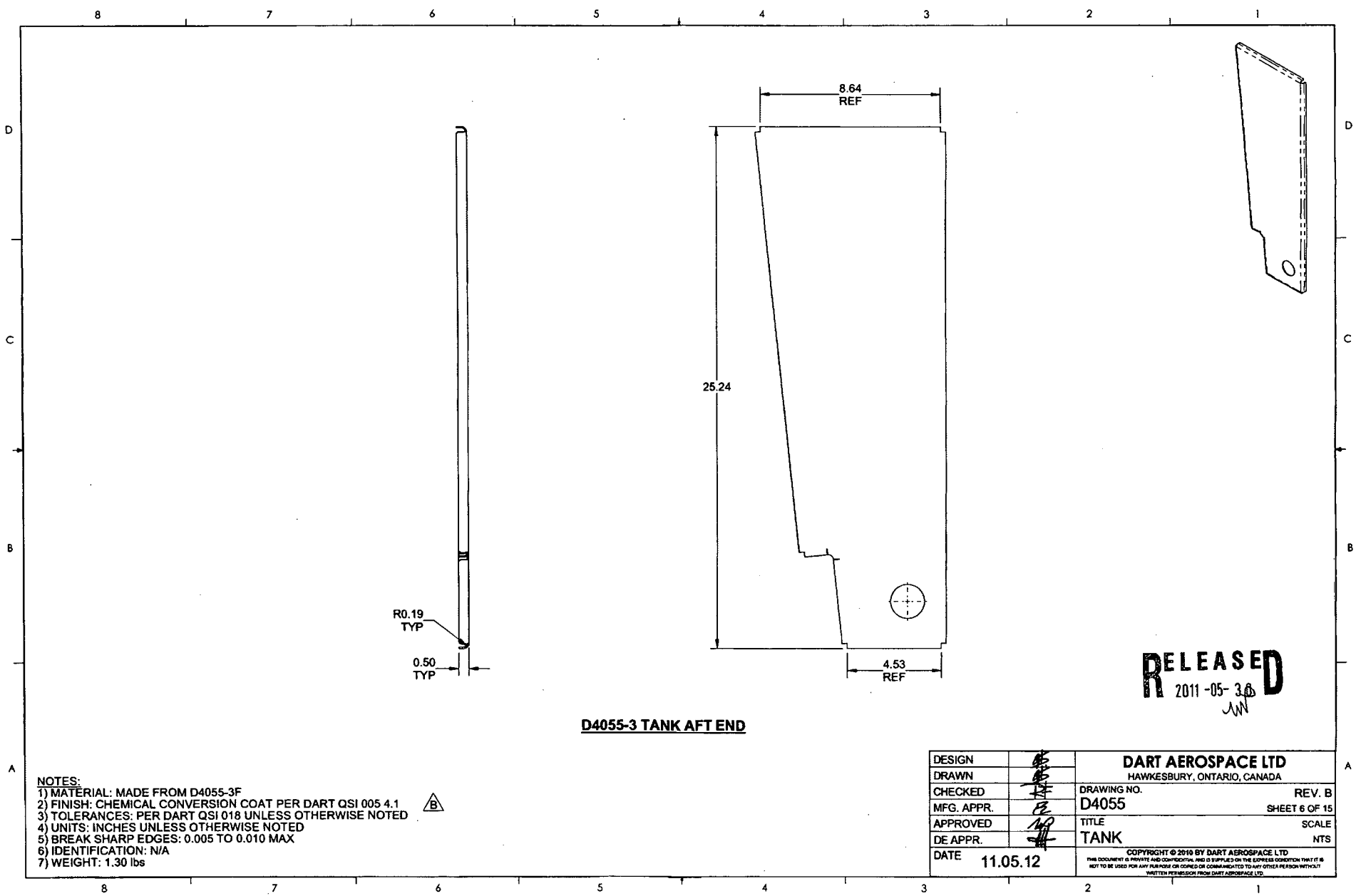
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74907



D4055-3 TANK AFT END

RELEASED
2011-05-30
JW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs
- B

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. B
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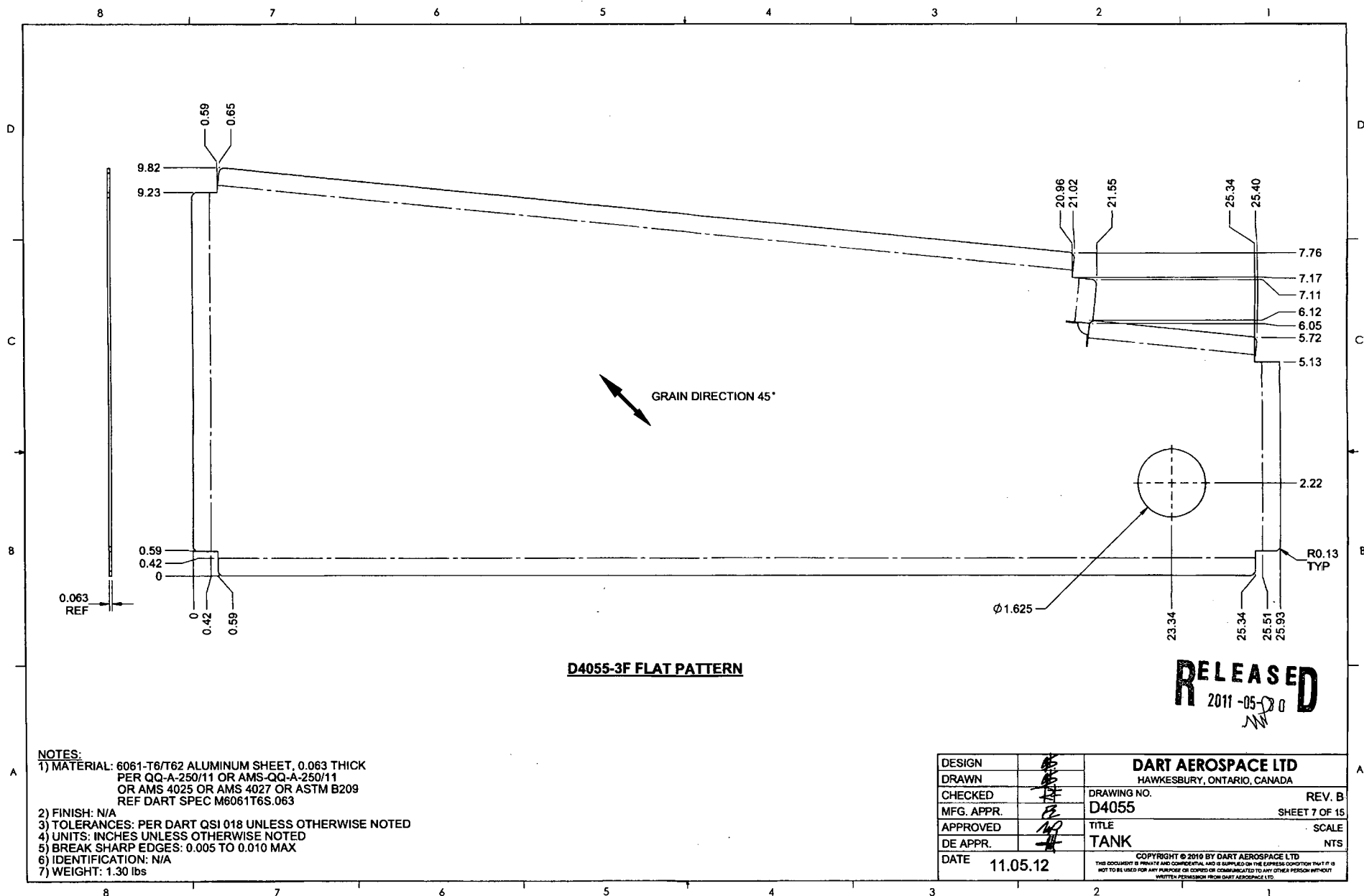
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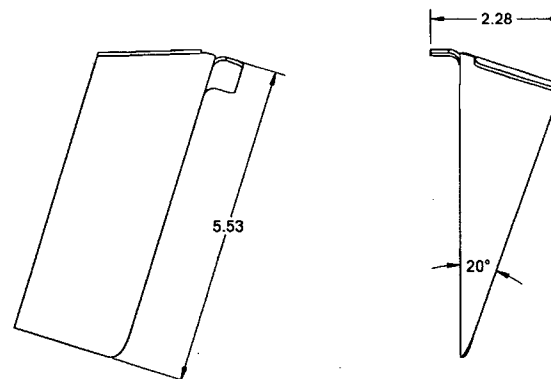
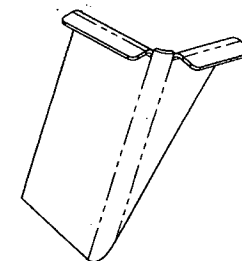
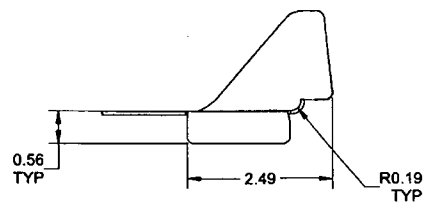
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74907



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NW

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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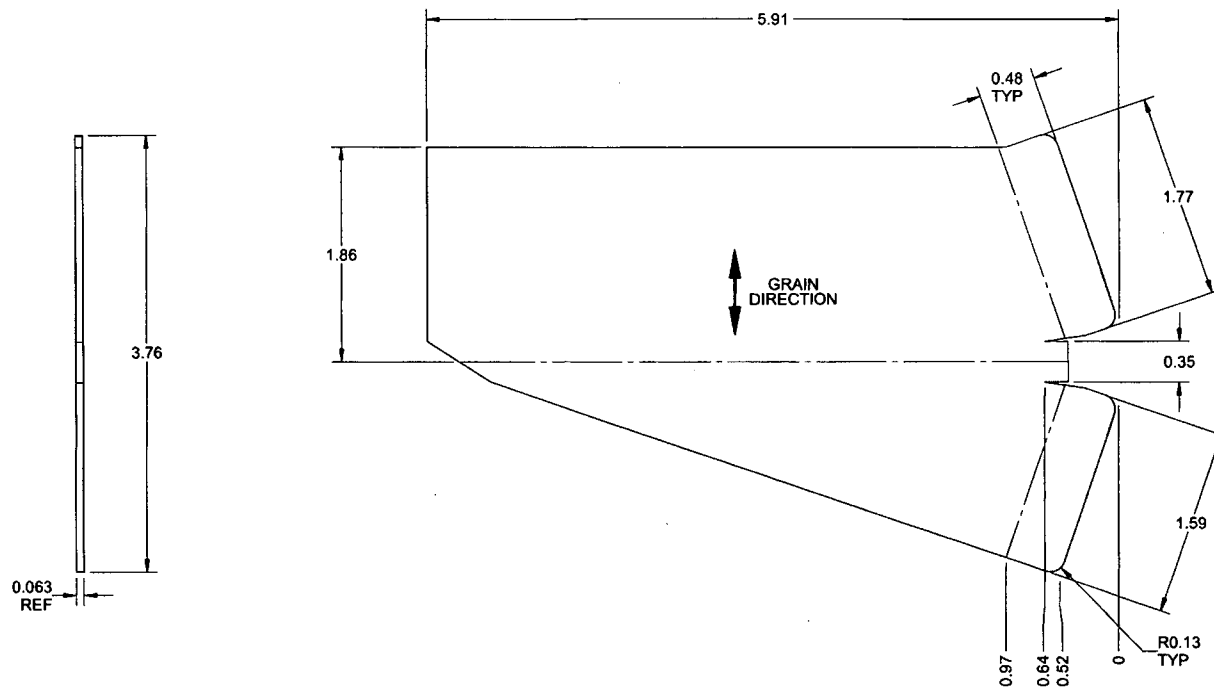
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D4055-5F FLAT PATTERN

RELEASED
2011-05-30
AM

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 9 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

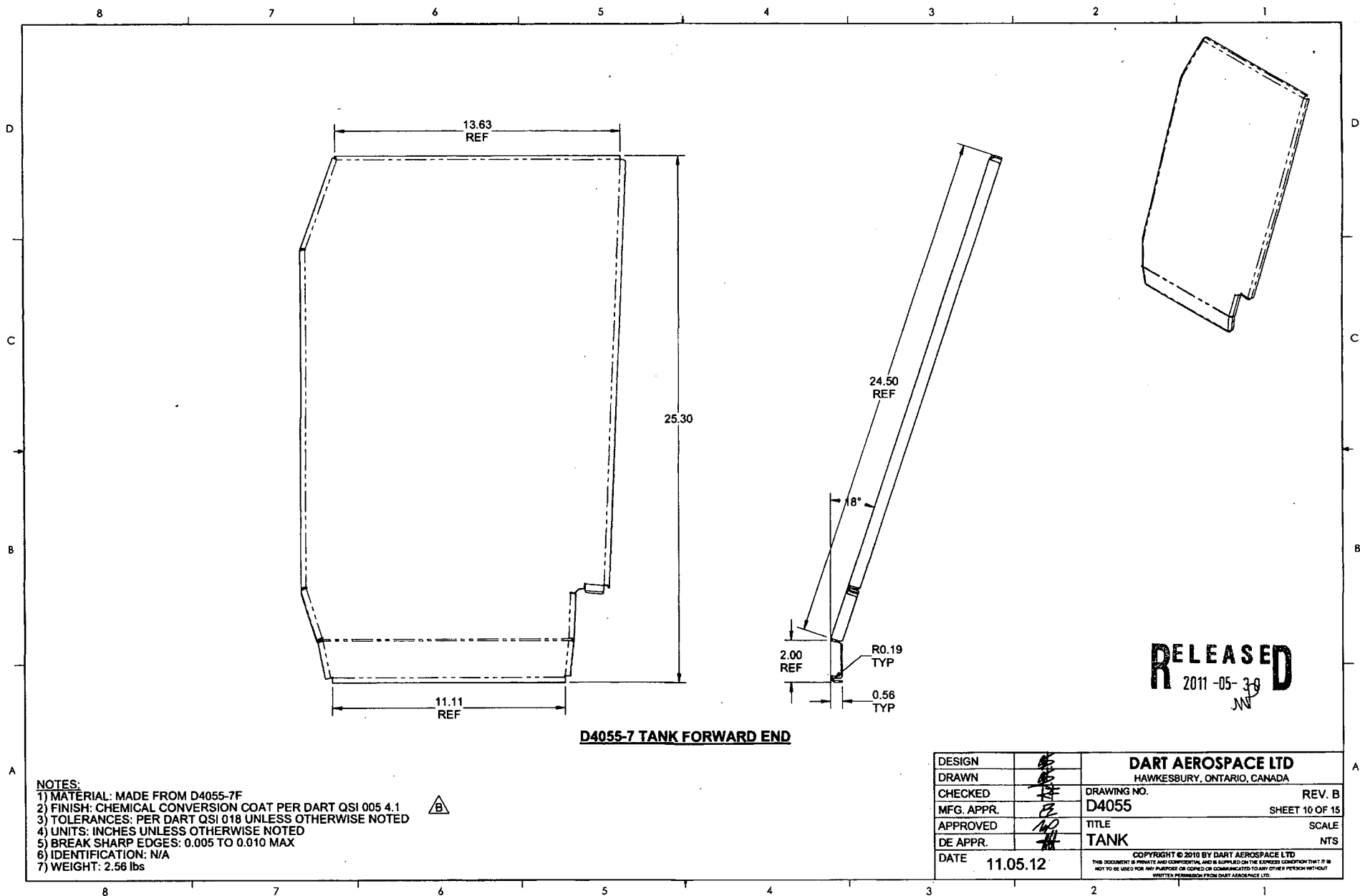
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



RELEASED
2011-05-30
JW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-7F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.56 lbs



D4055-7 TANK FORWARD END

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D4055	SHEET 10 OF 15
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

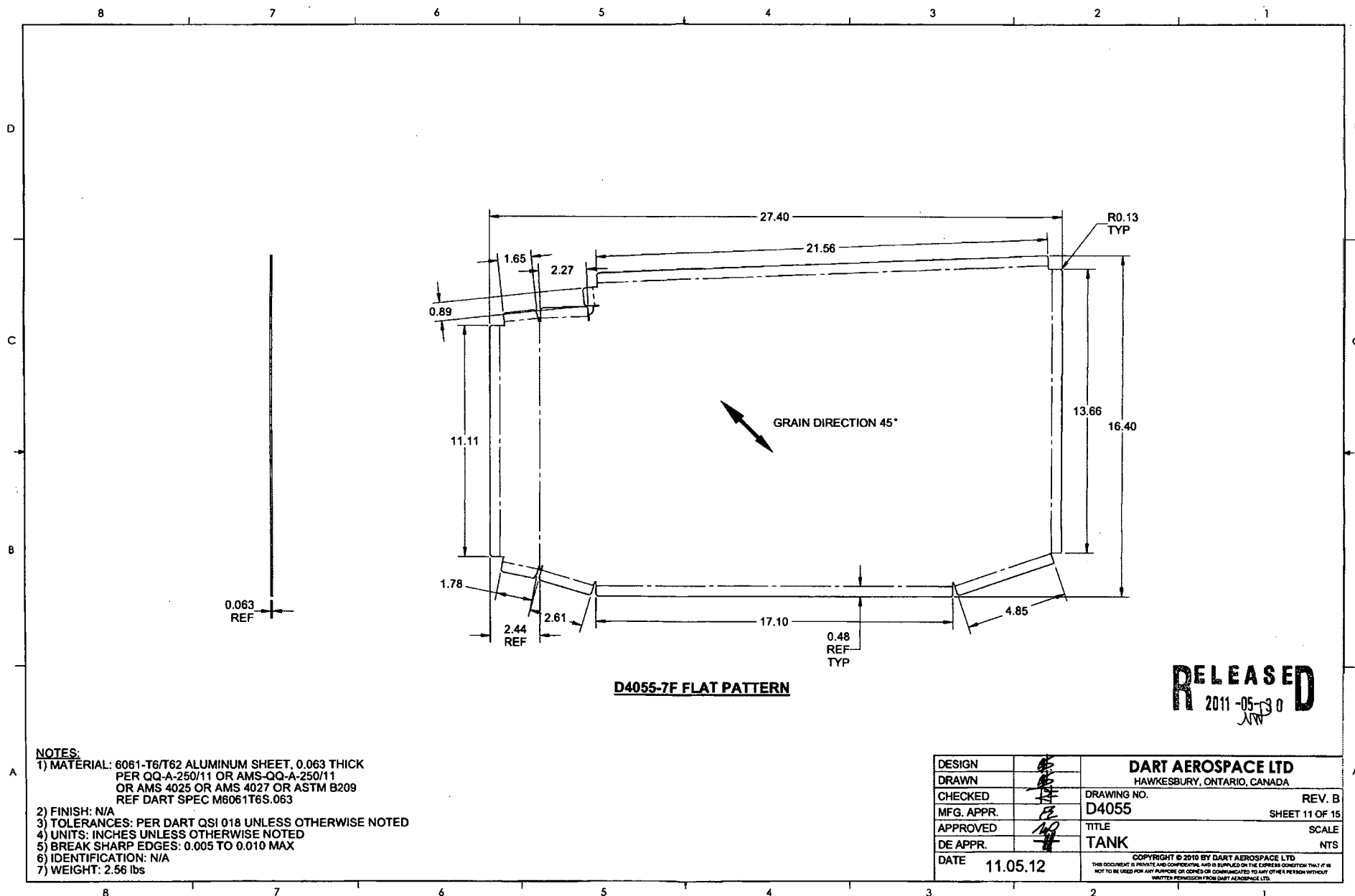
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4055	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 11 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

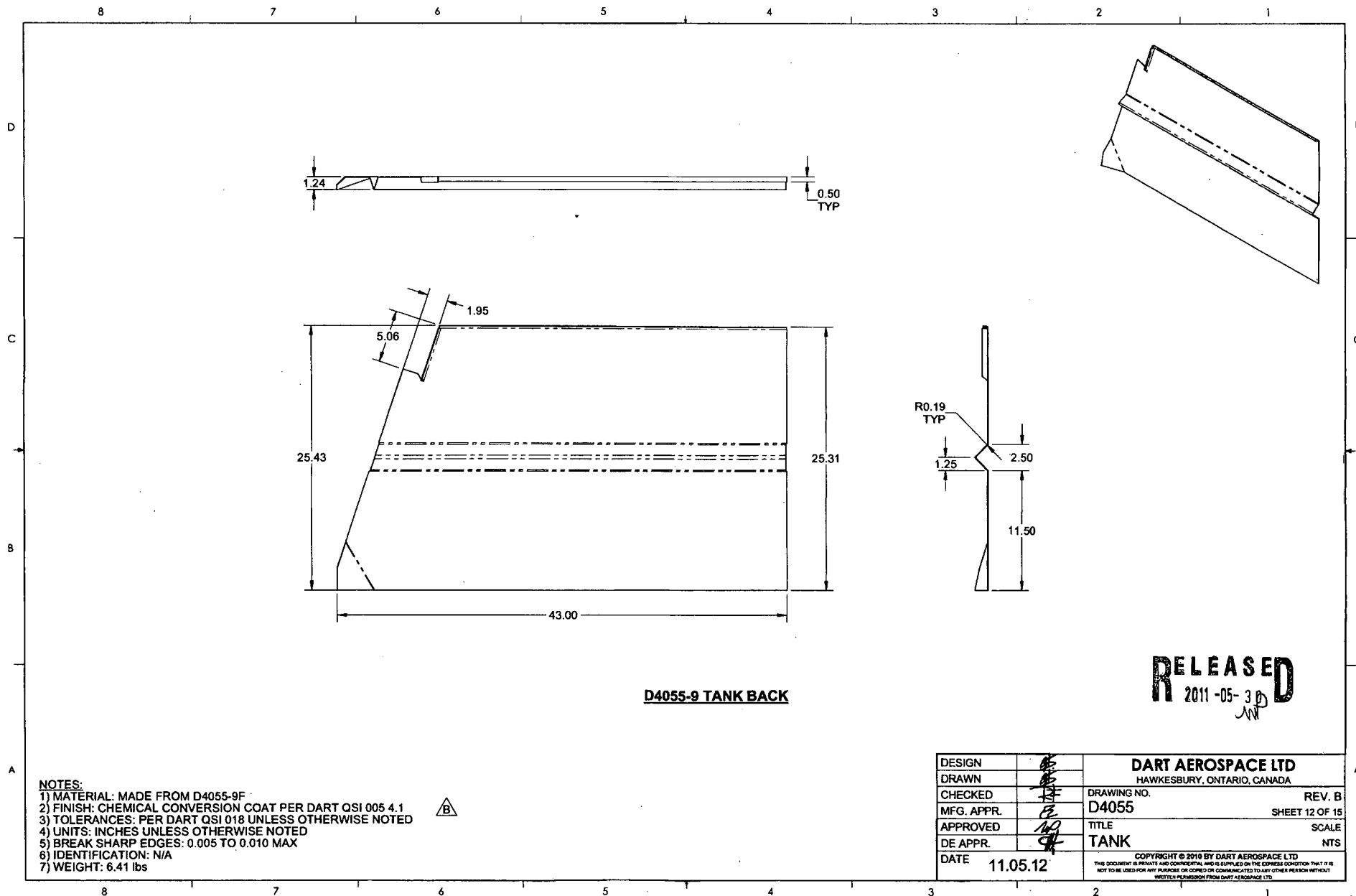
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



NOTES:

- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs



RELEASED
2011-05-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. B
MFG. APPR.		SHEET 12 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

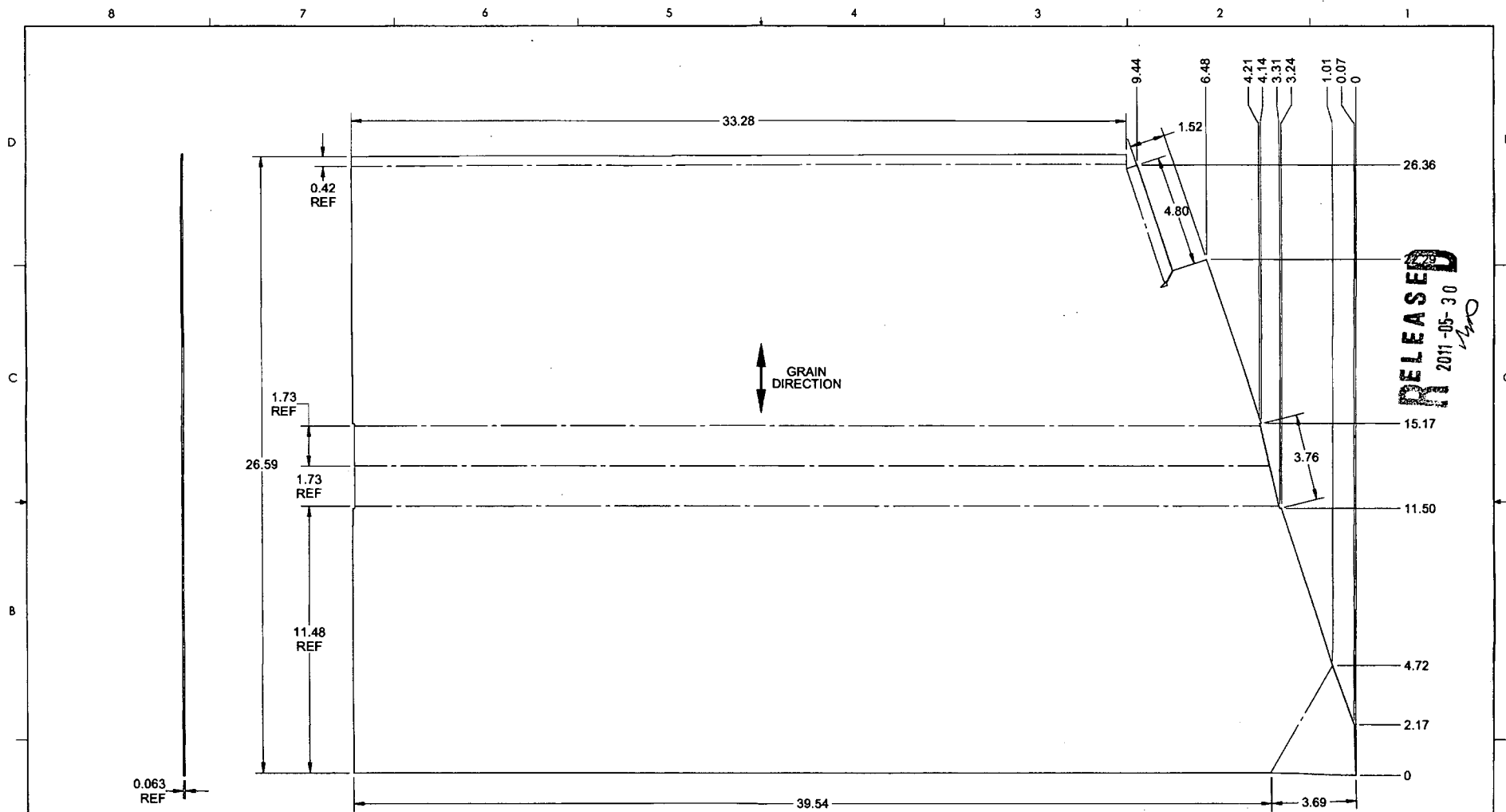
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

D4055-9F FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 13 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

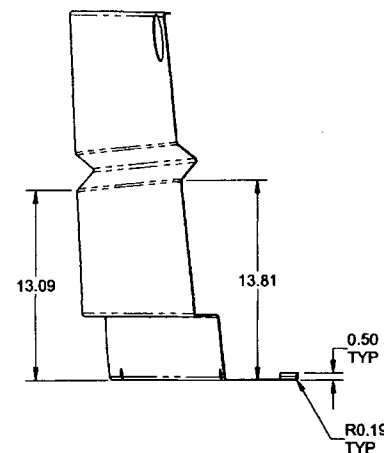
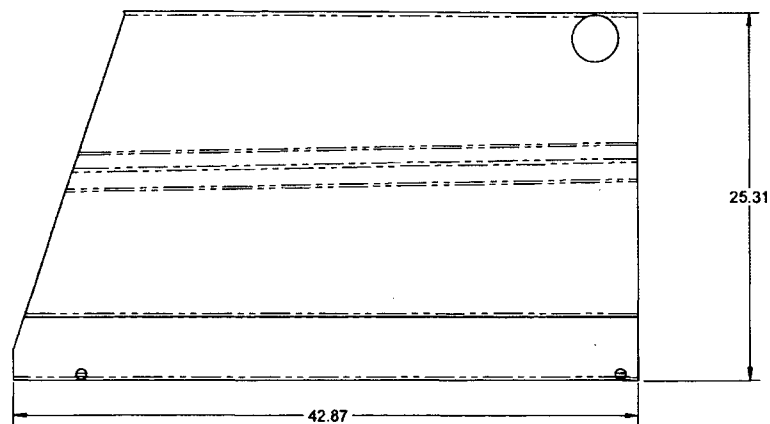
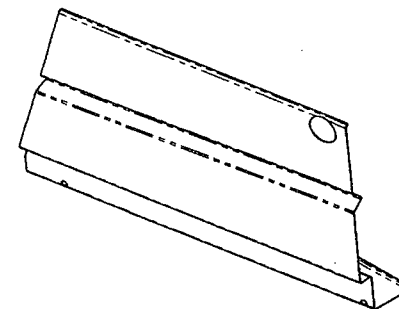
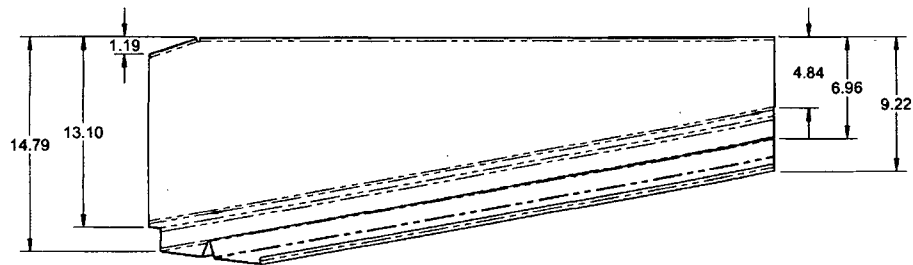
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



D4055-11 TANK FRONT AND BOTTOM

RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

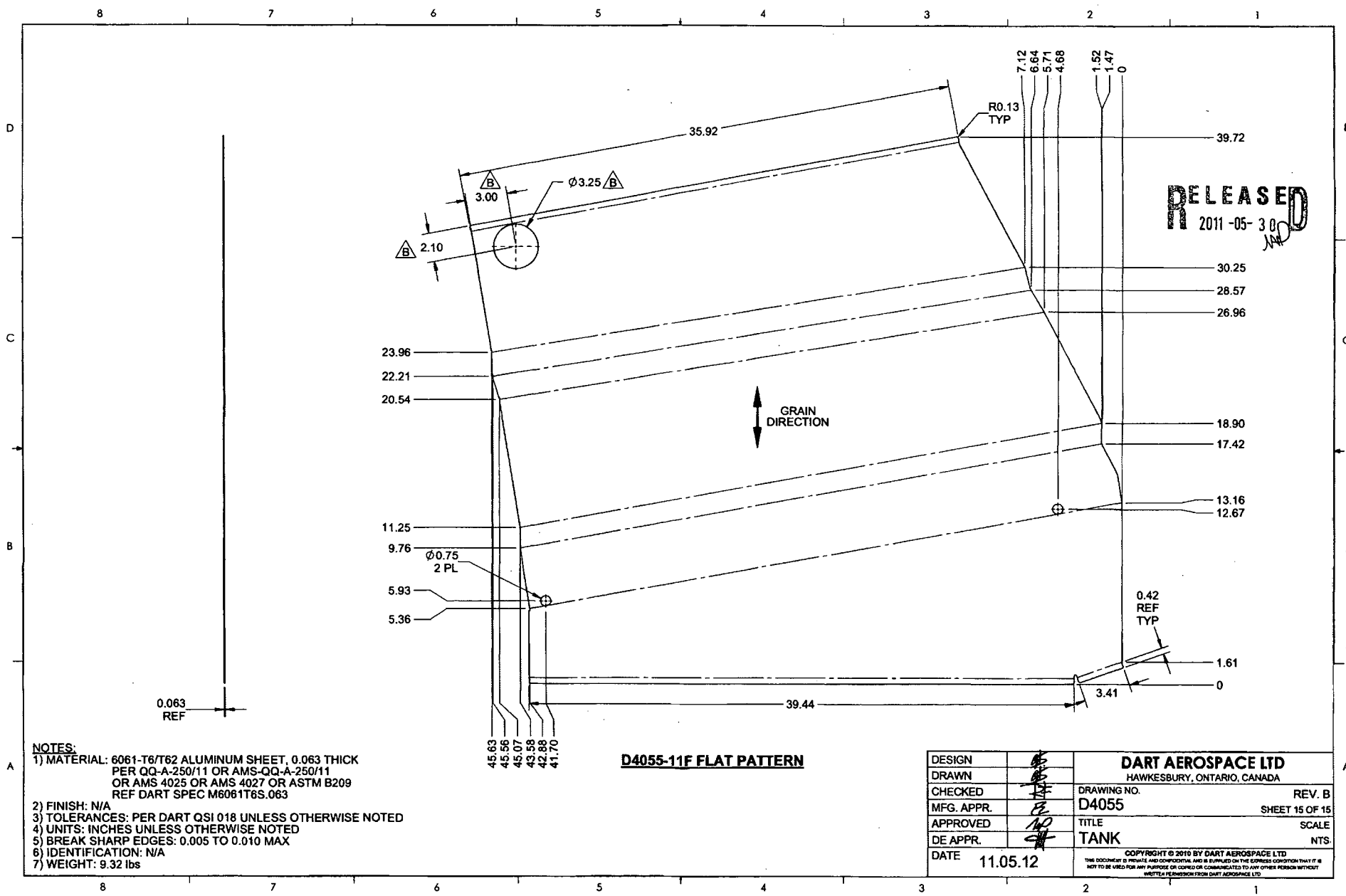
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74907



RELEASED
2011-05-30

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs

D4055-11F FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 15 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS.
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15139

Purchase Order Date 10/12/11

PO Print Date 10/12/11

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone

514 630 4877

Vendor Fax

514 630 4849

Vendor Account Nbr

Buyer

Linda Lacelle

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4055-11P	Tank Front and Bottom	10/21/11 Yes	5.00 Each	FedEx PI collect	\$115.0000	\$575.00
Special Inst: MAKE PER DRWG D4055 REV.B							
2	D4055-5P	Tank Upper Cut Out	10/21/11 Yes	5.00 Each	FedEx PI collect	\$115.0000	\$575.00

Special Inst: MAKE PER DRWG D4055 REV.B

PO Total:

\$1,150.00

Change Nbr:

1

Change Date: 10/12/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE				N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR	DY	MO	AN		
28	10	11		0472742	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0238305	PO15139	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
5	D4055-5P	TANK UPPER CUT OUT CERTIFICATE OF CONFORMANCE REQ
MFG. JOB# J0238305 - 001 QTY 5 pcs		

EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE PRÉSENTÉES

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 7 OUR JOB NO J0238305 SHIPPING MEMO 0472742

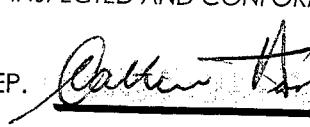
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	5 PCS	PO15139	D4055-5P	B	TANK UPPER CUT OUT	B

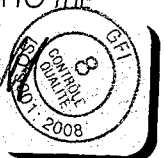
MATERIAL .063 THK AL 6061-T6 (AMS-QQ-A250/11) SUPPLIED BY SAMUEL / ALCOA INC MAT. REL. NO. 613714

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0238305-001 (5 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 28 OCTOBER 2011

G.F.I. Q.C. REP. 



**LES MÉTAUX
SPÉCIALISÉS
SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: August 16, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0079020

Customer's order #:

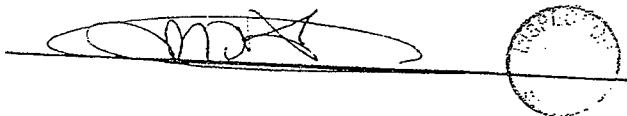
de commande SSMQ: 470993
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	1	.0630" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	613714

Bien à vous,
Yours truly,



CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722
Ship From: RIVERDALE, IA.

1263222
Ship Date 2011-07-01
B.L. No. 6040526
Invoice No. 00000
Alcoa No. Item 1000291425-1
P.O. No./Govt Contract No. C63748 Ln#: 1
Customer SAMUEL SON & CO LT G041094947R05
DCE-91425-1

Page 1 of 2

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URPE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 - .125) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK
ASTMB209 REV 07 CMMPO25 REV S ((MARKED))
KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/- 30 %
CQR 0210640 REV 05 CUST REQ 11-06-11 *** W/E 11-06-18 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	315871	613714	2326	57	PC	27107 27707 47004

Notes for CQR: 0210640.5
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.5 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T6	Long Transv.	Max KSI	Max KSI	PCT
		Min 42.0	35.0	10

Chemical Composition

Alloy	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total
Alloy 6061	Max 0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot: 613714	Min 0.40	0.15	0.15	0.8	0.04					

Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	UTS	TYS	EL4D
T6	Long Transv.	Max KSI	Max KSI	PCT
		Test 2	50.2	44.6
			51.1	45.6
				10.5
				10.3

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

[Signature]
 Malcolm Murphy
 Director of Manufacturing Davenport Works

[Signature]
 Terrence Thom
 Quality Assurance Manager

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722
 Ship From: RIVERDALE, IA.

1263222	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2011-07-01	6040526	00000	1000291425-1
P.O. No./Govt Contract No.	Customer	Alcoa Item	
C63748 Ln#: 1	SAMUEL SON & CO LT G041094947R05		
			DCE-91425-1

Page 2 of 2

Lot: 613714 - Mechanical, Physical, Metallography, Quantometer Results (cont.)
 Cast Number Chemical - OBS SI FE CU MN MG CR ZN TI
 H9334105 Actuals 0.65 0.4 0.25 0.07 1.0 0.16 0.06 0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States